



Dart Aerospace Ltd.
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K6A 1K7
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D2975
Job Sheet 213692



Part No: D2975

Job Qty: 4 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/20

Job Tracking No:

Due Date: 10/15/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C IPP: C 02.10.23 Re-format KJ IPP Rev:D Now on Waterjet 06-11-21 JLM IPP REV:E 13.04.08 AS
PER DWG REV.B DD VERF:JLM IPP REV:F 14.02.05 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		10/14/20	0.17	0.40	Waterjet - Flow		<i>on 20/10/02</i>
120	QC 8	4 pcs		10/14/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

DAS
40
9-89

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130	Small Fab - Brake NC - B4B	4 pcs	10/14/20	0.25 0.14	QC 8 - 82	
					Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
150	Large Fab - Welded Assy-2-B4B	4 pcs	10/14/20	0.00 1.64	Small Fab - Brake - 3 - B4B	OCT 07 2020
					Large Fab - 1 - B4B	<i>EL 10-7-20</i>
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
155	QC 9	4 pcs	10/14/20	0.00 0.00	QC 9 - 10	
					QC 9 - 18	DAS
					QC 9 - 24	24
					QC 9 - 43	9-89
					QC 9 - 50	
					QC 9 - 9	
160	QC 5	4 pcs	10/14/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	24
					QC 5 - 3	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
170	Spray Paint - 2 - B4B	4 pcs	10/15/20	0.00 0.13	Spray Paint - 1 - B4B	DAS
					Spray Paint - 2 - B4B	87 OCT 11 2020
					Spray Paint - 3 - B4B	9-89
					Spray Paint - 4 - B4B	
180	QC 3	4 pcs	10/15/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	

				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	OCT 13 2020 40 99
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
190	Packaging 3-1 - Stock - B4B	4 pcs	10/15/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 37 - B4B
200	QC 21 - SA	4 pcs	10/15/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

Part Op 100 - 1-Cut as per Dwg D2975

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg) Deburr if necessary Form as per dwg D2975 using DT8261 & DT8326

150 - ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M139076

155 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - Coat entire top concave surface with a layer of TEXTURE COATING as per dwg QSI 005 4.9

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.1032 sf (.2758 ea)	100-Waterjet - Flow - 1	5292091

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	175	0

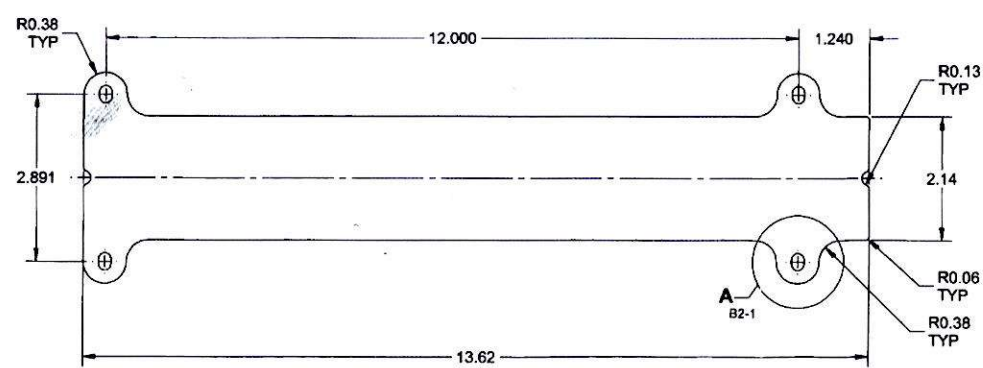
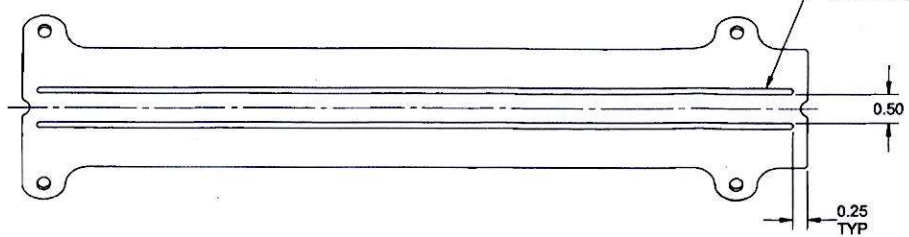
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.220Inches $\pm$ 0.010	0.230 0.210		
2	Wearplate	0.300Inches $\pm$ 0.010	0.310 0.290		
3	Wearplate	2.141Inches $\pm$ 0.010	2.151 2.131		
4	Wearplate	2.891Inches $\pm$ 0.010	2.901 2.881		
5	Wearplate	0.375Inches $\pm$ 0.010	0.385 0.365		
6	Wearplate	12.000Inches $\pm$ 0.010	12.010 11.990		
7	Wearplate	1.240Inches $\pm$ 0.010	1.250 1.230		
8	Wearplate	0.060Inches $\pm$ 0.030	0.090 0.030	Radius	
9	Wearplate	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	

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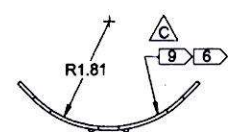
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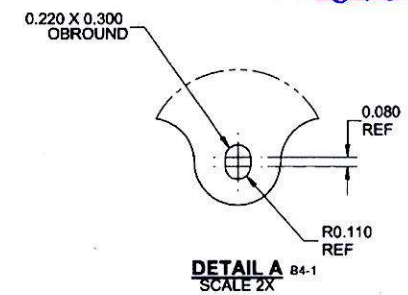
D2975 WEARPLATE
MAKE FROM D2975F



D2975F FLAT PATTERN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213692



DETAIL A
SCALE 2X

RELEASED
2014-02-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 16 GAUGE (0.063 THICK), REF. DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH P/N D2975 AND B/N AS PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
 - 7) WEIGHT: 0.60 lbs
 - 8) WELDING AS PER DART QSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER DART QSI 005 4.9

C	CHANGE NOTE 9 (ZN A4 AND D2), REF: NCR13-3166	SFM	13.10.25
B	FORMAT TO CURRENT STANDARD, AISI 304/316SS WAS AISI 1010-1025 STEEL, REMOVE FINISH NOTE, ADD NOTE 9, ROCKGUARD COATING (ZN A8-1), REF CIR 12-13	DB	12.12.14
A	NEW RELEASE	RF	00.03.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2975	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	13.10.25	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S304490



Part: D2975

Job No: 213692

Serial No/Batch: S304490

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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Date: 10/02/20